

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002711**Date Inspected:** 28-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1930**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Deck Panel				

**Summary of Items Observed:**

Caltrans Quality Assurance Inspector Mr. David Kelsey (Caltrans QA Inspector) arrived at Shanghai Zhenhua Port Machinery Co (ZPMC) to observe the ZPMC Quality Control Inspectors noted below perform the duties and responsibilities as outlined in the Welding Quality Control Plan (WQCP), Contract Special Provisions and to randomly inspect the in-process welding fabrication at ZPMC fabrication facility for the Orthotropic Box Girder (OBG) and Tower bridge structural components.

CWI Inspector: NA No welding observed

The Caltrans QA Inspector Mr. David Kelsey performed Final Visual Testing (VT) on DP004-001; partial penetration repair welds 001 thru 006. This inspector marked and measured several non-compliant visual indications of the ZPMC repaired areas such as weld profile (required smooth transition with weld into parent material), gouges, underfill and incomplete fusion on welds 001 & 006. Results and repair locations were recorded on the OBG deck panel weld inspection report and turned into the appropriate personnel and filed in the deck panel log book.

The Caltrans QA Inspector performed Magnetic Particle Testing (MT) verification of the QC MT Inspected and accepted welds. QA Inspector's MT verification appears to be acceptable with AWS D1.5-02 section 6.26.2.1 & 6.26.2.3 Reference QA Magnetic Particle Test Report TL-6028 dated 5-28-08 for specific test data.

**Summary of Conversations:**

None Noted.

**Comments**

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry 858-344-2712, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Kelsey,David	Quality Assurance Inspector
<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer

---